Work Order ID 108450 October-17-13 1:31:11 PM

108450

Page 1

Revision ID:	D2002-015 Knob	, and the second second	in an est on the control of the second	Accept	*N900	040	100)* s	etup Stai	I M	S1* S2*
Start Date: Required Date: Reference:		tart Qty: 6.00 Req'd Qty: 6.00	*6* *6*	Č	Cust Item I Customer:	D:					
Approvals:		MLJ	Date: /3-/0-			ate:		R	tun Stai Sto	171	R1* R2*
Sequence ID/ Work Center II		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	on Nbr		- 							
D2002	Rev A										:
1 \\n\ Doosan \\Doosan \Lathe		Memo 1-Turn as p FOLIO RE' DWG REV		0.00 AS 0.00 40 0.00 3	13/11/62			9			
*1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 	Q	2-Deburr as C2- Inspect parts off n Memo	·	0.00 0.00 40 9-89	13/11/02 -10-3/			q		·	<u></u>

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	<u></u>								QA Closed:	Da	te:
Work Ordei	: -				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	o				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verificatio	n QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
Onapproved		L	<u> </u>		F	AULT CATE	GORY		<u> </u>		
Landin	g Gear				General						
	Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in Torque W Turning S	Crimped t n Strip in Bend Vaves in E equence	Tube Extrusion		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Instruct Mainte Mislabe Misrea Offset Out of Out of	ion Incomplete tions Incomplete/ enance eled d Calibration Sequence	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
i	Wave/Tw	ist in Tub	oe e		Folio	Outside	e Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 108450	Wก็	rk	Orde	er ID	108	450
----------------------	-----	----	------	-------	-----	-----

108450

Page 2

October-17-13 1:31:11 PM

Required Date: 10/17/13

Item ID:

D2002-015

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name: Knob

10/17/13

Start Otv: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

QC: _____ Date: ____

Process Plan: Date: Tooling:

Date:

Date:

Run

Stop

Sequence ID/ Work Center ID

120

120

QC: Quality Control Operation Description

QC8- Inspect parts - second check

Memo

Memo

Set Up/ **Run Hours**

SPC (Y/N):

0.00

0.00

13/11/05

Tool ID

Tool # Plan Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

130

130

Packaging

Packaging

Identify as per dwg & Stock Location.

QC21- Final Inspection - Work Order Release

0.00

DAS

140

Ouality Control

Memo

0.00

0.00

		•
ι:	Date:	

NCR:	Yes /	No
11011.		

WORK ORDER NON-CONFORMANCE / UPDATE

	•							•		QA Closed:	Dat	e:
Work Order	, .				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No	o				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	l ir	nitial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data									······			·
quip/Tooling				:		1						
Operator		İ	- 1			1						
Material												
Setup						Ì						
Other					•		- ' ^					
Process						1	,					
Supplier												
Fraining											5	
Jnapproved		ļ				-						
					F	AUL	T CATE	GORY				
Landin	g Gear				General						_	
L	Bending				Bend		Grain			Ovalized		Pressure/Forced
L	Centre No	ot Conce	ntric to	o/s	_BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	t [Weld
L	Crushed/	Crimped			Burrs		Instruct	tions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Ш	Mainte	enance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
	Ripples ir			L	Drill Holes	Ш	Offset					
1	Torque V			n L	Drawing	-		Calibration				
1	Turning S				Finish	Ш	Out of S	Sequence			<u>.</u>	
•	Wave/Tw	vist in Tul	эе		Folio	1 1	Outside	Dimensions				

Picklist Print

October-17-13 1:31:11 PM

Work Order ID:

108450

Parent Item:

D2002-015

Parent Item Name:

Knob

Start Date: 10/17/13

Required Date: 10/17/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP C00.05.18Added inspection level 8EC

IPP Rev:D Now on Doosan Lathe JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500 DELRIN ROUND BAR 1.	25"	Purchased	No	···			f	16.5010		0.3	SE	13-	10-3
				Location		Loc Qty	Lo	c Code					
				MAT018		16.501							

16.501

m126596

									DQA:	Date	:
NCR: Y	es / N	lo			WORK ORDER NON-O	CONFORI	MANCE / UPI	DATE	QA Closed:	 Date	
				-	DISPOSITION			AGAINST DE	-		•
Work Orde	r:		····		_	,			1	·	
Part N	io				Rework Scrap Use-as-is	4 1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update] Illen	Large Fab	Composite	, Recysto	Supplier	Julia
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Da	te Step	Qty		or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator									İ		
Material											
Setup	_										
Other				1							
Process											
Supplier											
Training											
Unapproved						ļ					
		 	•	· · · · · · · · · · · · · · · · · · ·		AULT CATE	GORY				
Landii	ng Gear				General			_	7	_	¬
	Bend	•		ļ	Bend	Grain		<u> </u>	Ovalized		Pressure/Forced
	Centi	e Not Conce	entric to	o/s	BOM/Route	Hardwa	· -	_	Over/Under	 	Temperature/Cure
	Cracl				Broken/Damaged	—	ion Incomplete		Part Incorre		Weld
	_	ed/Crimped	4		Burrs	\blacksquare	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		enance		Part Moved		
	—	Treat		<u> </u>	Countersink	Mislab	eled		Positioned \		7
	Inspe	ction Strip i	n Tube		Cut Too Short	Misrea	d	,	Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	108450
Description: Knob	Part Number:	D2002-015
Inspection Dwg: D2002-015 Rev: A		Page 1 of 1

	FIR	ST ARTICLE	INSPEC ⁻	TION CH	ECKLIST		
	[X First Ar	ticle [Pro	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	1.0	mments
1.250	+/-0.010	1.245		·			
0.194	+0.005/-0.000	-194					
0.625 x 0.220	+/-0.010	625 X 220	//				
0.063 x 45°	+/-0.010 x 0.5°	:063 L45°					
0.032/0.040	+/-0.008	.032	/		Mic PHD-09	200	, <u>40</u>
0.390/0.400	+/-0.010	.396	V		VERN PUD-12	. 1	- 40
R0.375	+0.005/-0.000	.378	/		,,	200	ah.
Measured by:		Audited by:	0-89		Prototype A		N/A
Date:	13/11/62	Date:	13/11/	105		Date:	N/A
Rev Date	Change					Revised by	Approved

Rev	Date	Change	Revised by	Approved
Α	08.09.05	New Issue	KJ/DD X	<i>X</i>

